

5/08


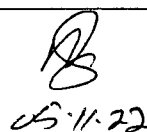
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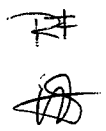
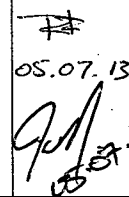
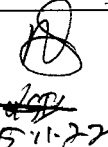
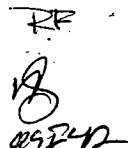
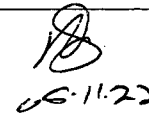
DART AEROSPACE LTD	Work Order:	22289
Description: Main Body	Part Number:	D3372-1
Dwg: D3372 Rev. A <i>page 4</i>	Qty:	25 26
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>JA</i>	05.01.25	25 25
2	MV	Cut blank: 1.500" x 3.000" x 4.450" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B3.000x01.500) Identify for D3372-1 Batch: <i>M6530</i>	<i>J.L</i>	05.07.12	25
3	MV	Machine D3372-1 as per Folio FA496 and Dwg D3372 Identify as D3372-1	<i>Ep</i>	05.07.14	25
4	QC2	Inspect parts as they come off the CNC machine	<i>Ep</i>	05.07.14	25
5	QC8	Second check	<i>me</i>	05.07.14	26
6	MV	Deburr	<i>Ep</i>	05.07.14	25
7	QC5	Inspect work to Step 6	<i>me</i>	05.07.14	26
8	FP	Chemical Conversion Coat as per QSI 005 4.1	<i>FF</i>	05.07.14	26
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask all holes	<i>MM</i>	05.11.15	26
10	QC3	Inspect Powder Coat	<i>CL</i>	05.11.15	26
11	ST	Identify and Stock	<i>Loc 59</i>	05.11.16	26 <i>CL</i>
12	AC	Cost / part <i>16.32</i>	<i>Syc</i>	05.11.21	26
13	DC	Close W/O <i>16.32</i> Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.01.18	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
11/05/01/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.07.13		- update dimension sheets	J-L	05.07.13			


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.07.13	3	- 1 part chamfer dimension is .730 instead of .630 - error in program - is part acceptable?		IT IS ACCEPTABLE FOR (1) PART FOR THIS W/O. UPDATE CNC PROGRAM TO CORRECT THE DIMENSION AS PER DUG.	 05.07.13	 05.11.22		 06.11.22

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/11/22

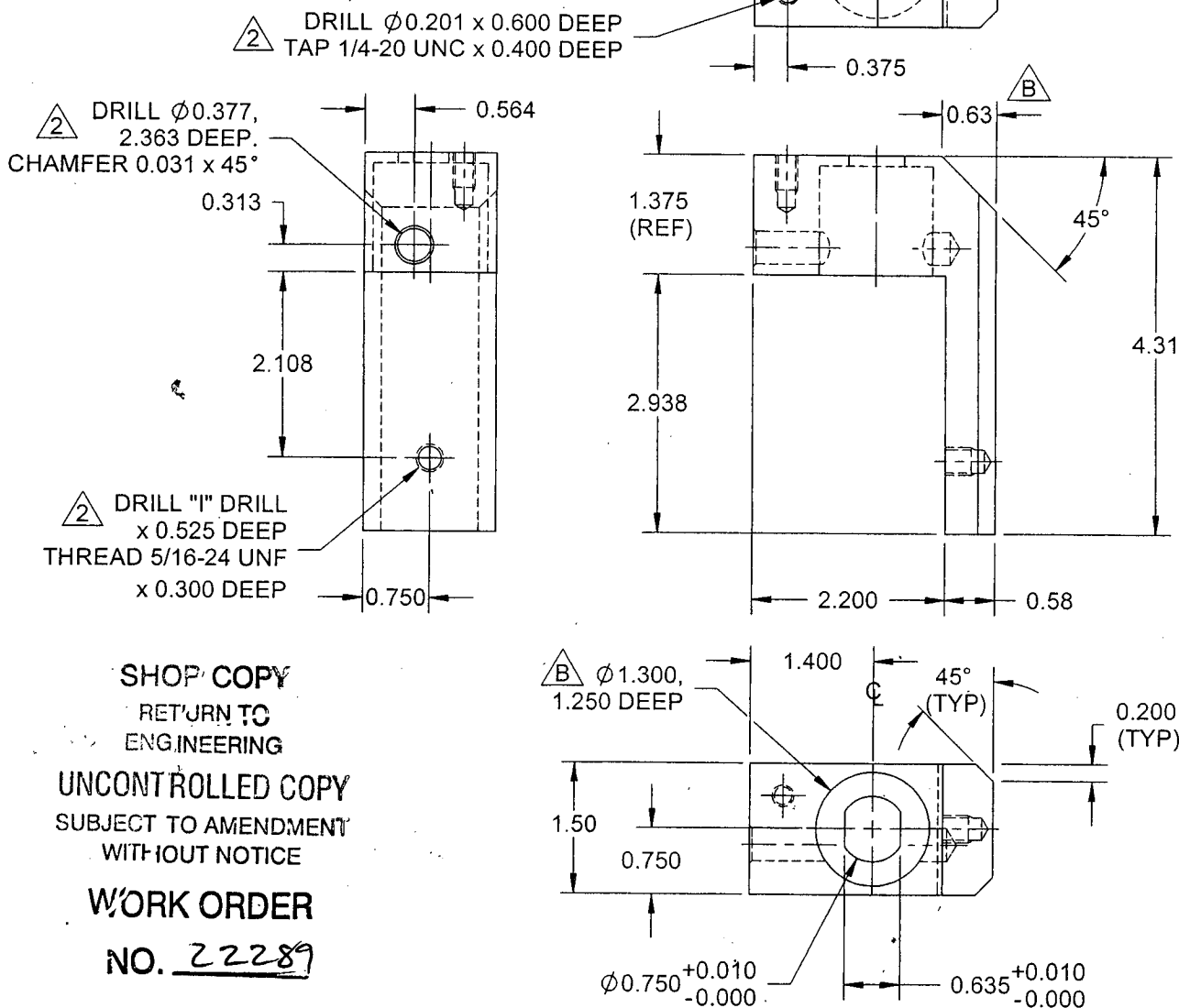
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED F	APPROVED 	DRAWING NO. D3372	REV. B SHEET 4 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

RELEASED
05/04/28



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22289

D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 25, 2005
03:20 pm

Work Order No : 0022289
Project Name : D3372-1
Project For : WK508
Work Order Type : Main
Main WO Number :
House Part Number : D3372-1
Description : Main Body
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 01-25-05
Est Finish Date : 02-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:12 am

Work Order No : 0022289
Project Name : D3372-1
Project For : WK508
Work Order Type : Main
Main WO Number :
House Part Number : D3372-1
Description : Main Body
Manufactured : Yes
Amount Req'd : 25
Amount Done : 0
Start Date : 01-25-05
Est Finish Date : 02-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	17.50	100.00		
Production Cost	0.00	304.07	100.00	0.00	304.07
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	16.25	100.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	304.07	100.00		
Margin	0.000	0.000			
Selling Cost	0.00	304.07			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-304.07)

MUS 0/B
u
11-13

Date: Monday, 14/11/2005 8:43:54 AM
User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MAIN BODY	
Job Number :	22289			
Estimate Number :	10446			
P.O. Number :		Part Number :	D33721	
This Issue :	14/11/2005	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3372 REV B	
First Issue :	/ /	Project Number :		
Previous Run :		Drawing Revision :	B	
	Type :	Material :		
	MACHINED PARTS	Due Date :	30/11/2005	Qty: 25 Um: Each
Written By :				
Checked & Approved By :				
Comment :	Est. A 05.01.18 New issue KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B3000X01500	6061-T6 Bar 3" x 1.5"
-----	--------------------	-----------------------

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: Cut blank: 1.500" x 3.000" x 4.450" long
Machine D3372-1 as per Folio FA496 and Dwg D3372
Identify as D3372-1
Deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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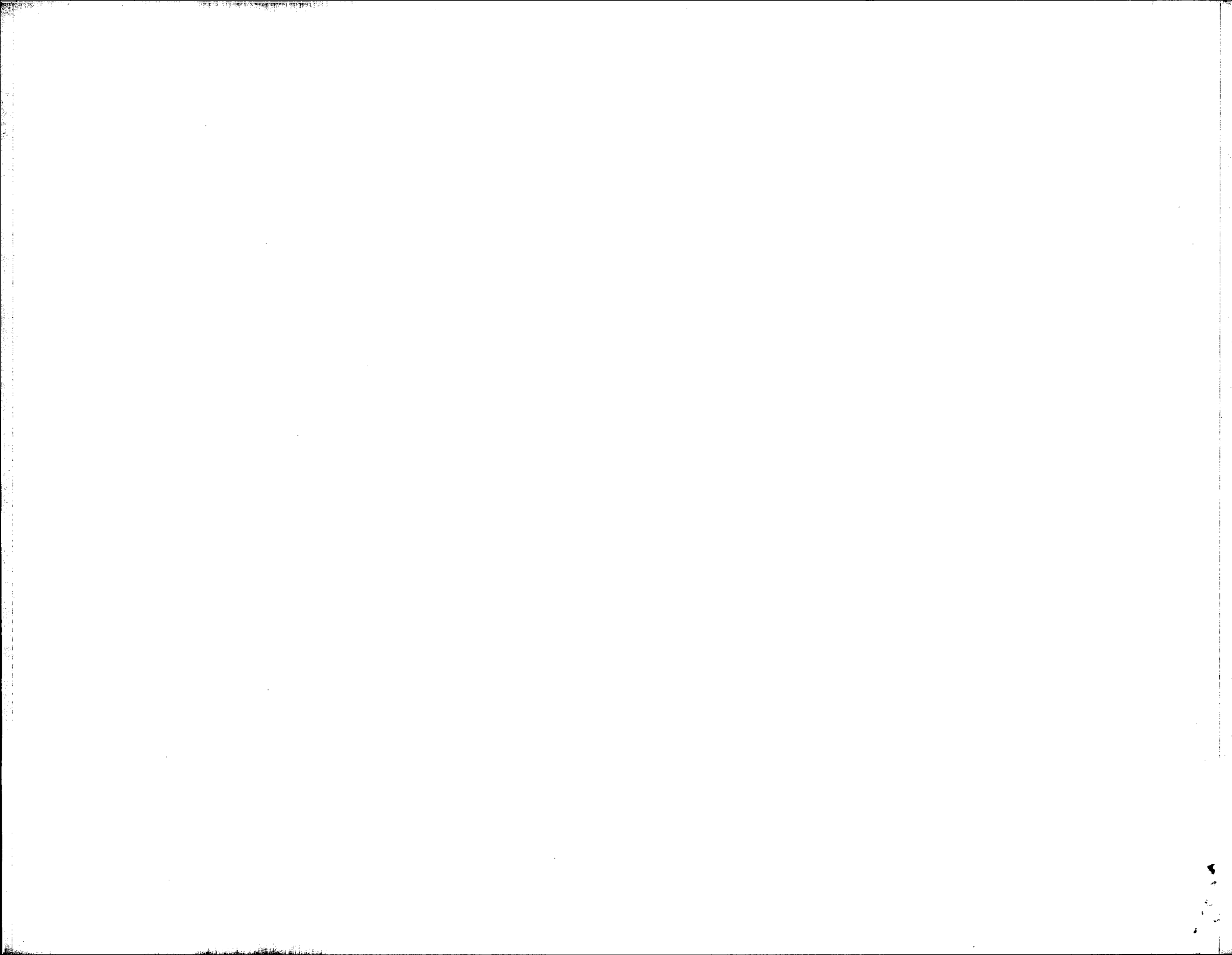


Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3



Date: Monday, 14/11/2005 8:43:54 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAIN BODY

Job Number: 22289

Part Number: D33721

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

